Work Order ID 61970

Quality Control

Memo

	ber 13, 2010 11:15:1	7 AM										Page 1
Item ID: Revision ID:	D3536-13			Accept				S	Setup	Start		
		Qty: 12.00 Qty: 12.00		HARA IIA IAU Hara IIA Iau	Cust Item I Customer:	D:				Stop		
Approvals:	Process Plan: QC:		Date:	Tooling: SPC (Y/N):		ate:		F	Run	Start Stop		
Sequence ID/ Work Center II	Qperat Descrij			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nb	r										
D3536	Rev A		* *** A STATE OF THE STATE OF T	<u> </u>								
Waterjet FLOW CNC Waterje		VATER JET Memo 1-Cut as per Deburr if nec	Dwg D3536 □I. cessary	0.00 0.00 Dwg Rev: Prog Rev	: ^ _ 🖂			B (C	<u>۹</u> .	-13	(14	<u> </u>
QC Quality Control	QC2- Ins	spect parts off ma	achine FAI/FAIB	0.00				出。	0 <u>-</u> 0	<u>1-3</u>		
120 	QC8- Ins	spect parts - seco Memo	nd check) 3 00.0 Co.0	05/13			(414))			

W/O:			WORK ORDER CHANGES								
DATE STEP			PRO	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			•								
Part No	:		PAR #:	Fault Category:	NCR: Y	es No DQ	A :	Date: _			
	R	esolution:		Disposition:	QA: N/C	Closed:		Date: _			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Annroyal	Approval			
DATE	STEP	Section A			Sign & Date	Section C	Approval Chief Eng	QC Inspector			
					1						
						:					

Work Order ID 61970

Monday, September 13, 2010 11:15:17 AM



Page 2

Item ID:

D3536-13

Accept

Setup Start

Run

Stop



Revision ID:

Start Date:

Item Name:

Gasket

9/13/2010

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference: Approvals:

QC:

Process Plan:

Date:

Tooling: SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Start

Stop



Required Date: 9/13/2010

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Memo

Date:

Identify as per dwg & Stock Location:

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

V 10-09.13

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W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRC	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cated	lorv:	NCR: Vas	No DO	Δ.	Date:	
T dit 140		solution:							
NCR:				R NON-CONFORMAL					
		Dinti(A)O	Corrective Action Section B			B Vanisia			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector
		•							
									,
•									

Picklist Print

Monday, September 13, 2010 11:15:17 AM

Work Order ID: 61970

Parent Item: D3536-13

Parent Item Name: Gasket



Start Date: 9/13/2010

Required Date: 9/13/2010

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063	15 115111 BB118 B118F 1111 1887	Purchased	No			100	sf	491.6133	0.8269	10.44505			
										,	B 10-9	9-13	

NEOPRENE SHEET 0.063

Location	<u>l</u>	Loc Oty	Loc Code		\sim
MAT		386.3602			$\mathcal{L}^{\prime\prime}$
	114691	105.9602			(14)
	115500	280.4		115400	
MAT052		105.2531			
	114176	105.2531			

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				·					
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	۱:	Date:	
	R	esolution:	Dispositio	n:	QA: N/C CI	osed:		Date: _	
NCR:	•		WORK ORD	ER NON-CONFORMAN	NCE (NCR	1)			
DATE	STEP	Description of NC		Section B Veri			Approval	Approval	
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
,									
				. -					
									·
									

DART AEROSPACE LTD	Work Order:	61470
Description: Gasket	Part Number:	D3536-13
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90	*		7 1301	
29.40	+/-0.030	29.40	ж		7	
27.40	+/-0.030	27.40	*		7	
23.90	+/-0.030	2390	¥.		τ	
18.98	+/-0.030	18.98	X		7	
14.07	+/-0.030	14.07	*		7	
9.15	+/-0.030	9.15	*		7	
5.65	+/-0.030	5,653	ير		V 1BO2	
3.90	+/-0.030	3,90	4		V	
8.00	+/-0.030	8.00	7		7	
14.00	+/-0.030	14.00	Ž.		7	
20.00	+/-0.030	20.00	%		Ť	
1.89	+/-0.030	1.881	*		V	
0.30	+/-0.030	. 3o3	X.		Ù	
0.30	+/-0.030	,304	*		J	
Ø0.19	+0.005/-0.001	,19	*		J	

Measured by:	围	Audited by:	Prototype Approval:	N/A
Date:	10-9-13	Date: 10/09/13	Date:	N/A

	Rev	Date	Change	Revised by	Approved
	Α	07.06.13	New Issue	KJ/JLM ox	B
•					

26.65 23.15 21.15 -17.65 0.90 9.15 5.65 -1.89 DETAIL A 3.90 #0.19 (TYP 3 PLS)

D3536-11 GASKET

32.90 29.40 -27.40 23.90 -18.98 0.90 - 5.65 1.89 DETAIL A 3.90 **¢**0.19 (TYP 4 PLS) 20.00 **D3536-13 GASKET**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT Q
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
 IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

Wb 6,970	
WD	
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NC. 1 OF 6

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SCALE 1:10

DRAWING NO.

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GASKET

06.10.25

NEW ISSUE

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									·
									
Part No	·	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	Re	solution:	Dispositio	n:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
DATE		Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Sect	ion C	Chief Eng	QC Inspector

DRAWING NO.

DART

AEROSPACE PORT HADLOCK,

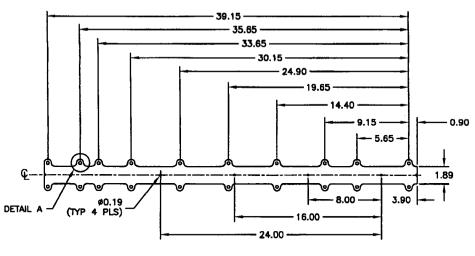
USA,

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06.10.25

GASKET





D3536-15 GASKET

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	21.80 —				ļ
DETAIL A	16.35				0.90
2.00			•		1.89
6.00	8.00			- \	ø0.19
	16.00 -			_	Ø0.19 (TYP 4 PLS)
	-	- 24.00			
	D35	<u> 36–21</u>	GASKE	[

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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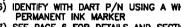
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PURPOSE

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7) SEE PAGE 6 FOR DETAILS AND SECTION

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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date:	
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DATE	STEP	Description of NC			ion B		cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
							-		
	-								

NO.

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21.22.19 48.20 -28.53 23.14 -17.75 -DETAIL A 2.00 1.89 - 6.00 0.90 - 16.00 ø0.19 (TYP 6 PLS) 24.00 32.00 39.00 48.00

D3536-23 GASKET

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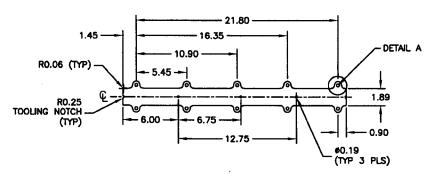
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PURPOSE

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

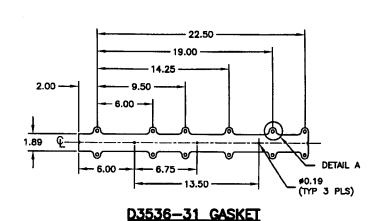


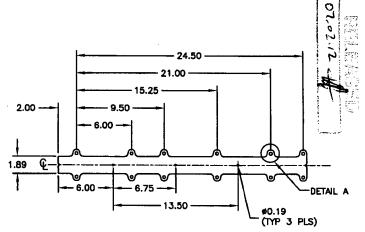
D3536-25 GASKET

W/O:			WO	RK ORDER CHANGE	3				
DATE	STEP	PRO	ROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA			
Resolution:			Disposition				Date:	<u></u>	
NCR:			WORK ORDE	R NON-CONFORMAN	ICE (NCR)			
		Description of NC		Corrective Action Section	Section B Verification			Ammunual	A
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sectio		Approval Chief Eng	Approval QC Inspector
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1:1	GASKET		06.10.25	
SCAI	TITLE		DATE	
SHEET 4 OF	D3536		7	
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PORT HADLOCK, WA		CB	CB	
DART AFROSPACE USA INC.	DART	DRAWN BY	DESIGN	





D3536-33 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- PART IS SYMMETRICAL ABOUT ©
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

-	23.25	
-	17.75	
2.00	4.75	
1.89 €		
6	.00 - 6.75 - 90.19 (TYP 2 PLS) DETA	AIL

D3536-35 GASKET

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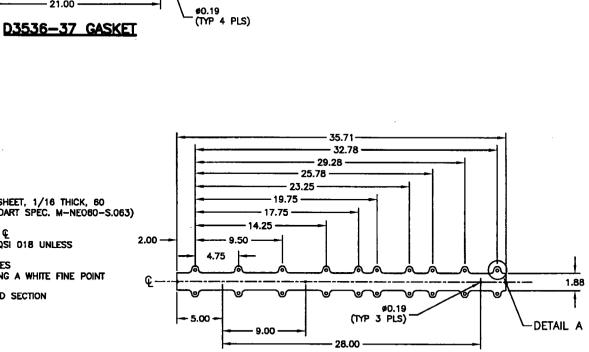
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06.10.25

GASKET

21.02.12



DETAIL A

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PURPOSE

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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

30.75

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2) FINISH: NONE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

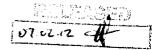
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

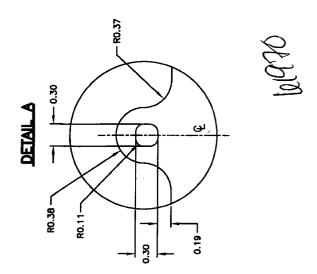
7) SEE PAGE 6 FOR DETAILS AND SECTION

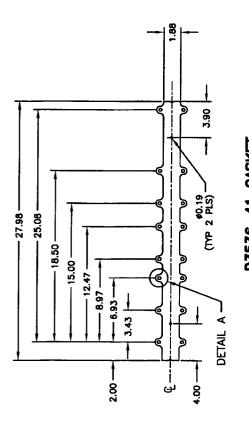
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PH	# #	D3536	SHEET 6 OF 6
DATE		TITLE	SCALE
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NOTES 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEOGO-S.063) FINISH: NONE
PART IS SYMMETRICAL ABOUT ©
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES
IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER ଅଧ୍ୟ

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